

Date: Tuesday, 4/25/2006 7:36:52 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE ASSEMBLY		
Job Number	: 26811B <i>2</i>					
Estimate Number	: 11180					
P.O. Number	: N/A			Part Number	: D2282043	
This Issue	: 4/25/2006		S.O. No. : N/A	Drawing Number	: D2282 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : SMALL /MED FAB	Drawing Revision	: E	
Previous Run	: 25128B			Material	: N/A	
Written By	: See comment below			Due Date	: 5/20/2006	
Checked & Approved By	: 06.04.25 w			Qty:	100	Um: Each
Comment	Est Rev:A	Removed from 9 Digit	05-12-02 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2281	Jack Saddle	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)	(30)
		Pick:	
	Qty Part Number	Description Batch	
	1 D2281	Saddle <u>B26814</u>	
			CPL 06-06-08
2.0	D22827	Tube	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s)	(30)
		Pick:	
	Qty Part Number	Description Batch	
	2 D2282-7	tube <u>B26817</u>	
			CPL 06-06-08
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Weld as per D2282-043 Saddle Assembly	
		Grind chamfers and ensure full penetration.	
	A/R ER316L SS	Filling Rod <u>M100527</u>	
		Dwg Rev: <u>E</u>	
4.0	QC5/9	WELD INSPECTION	
		Comment: WELD INSPECTION	

2x3 (2)
 2x5 27
 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:36:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 26811B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SA1 06/06/12

69

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/12 69

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SB 06/06/12

69

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

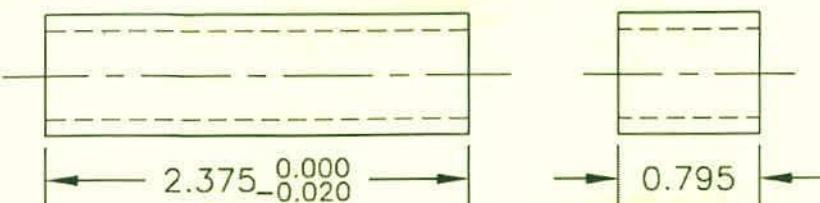
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

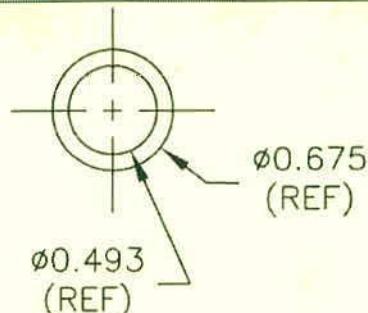
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ip</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
05/09/16



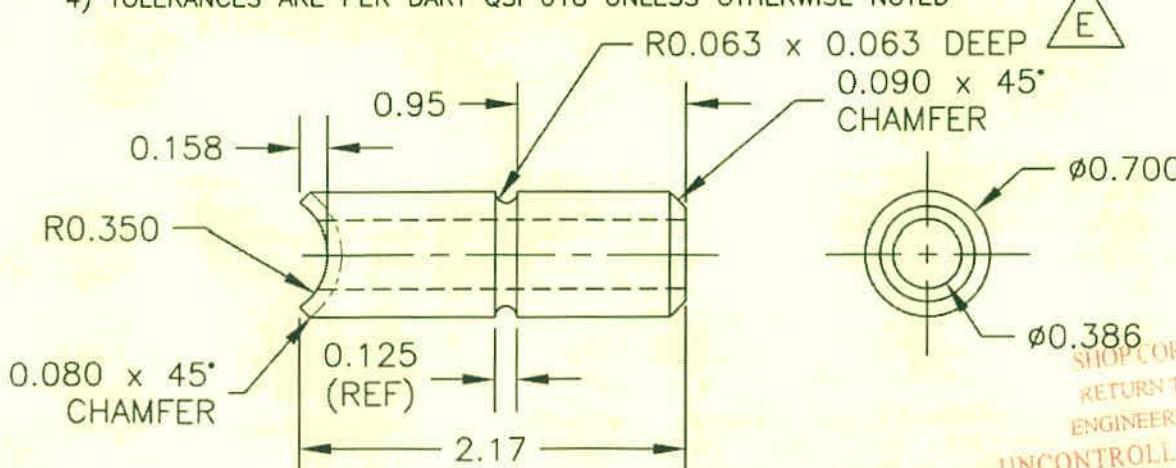
D2282-3

A triangular hazard symbol containing the letter 'D' is positioned to the left of the text 'D2282-7'.



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

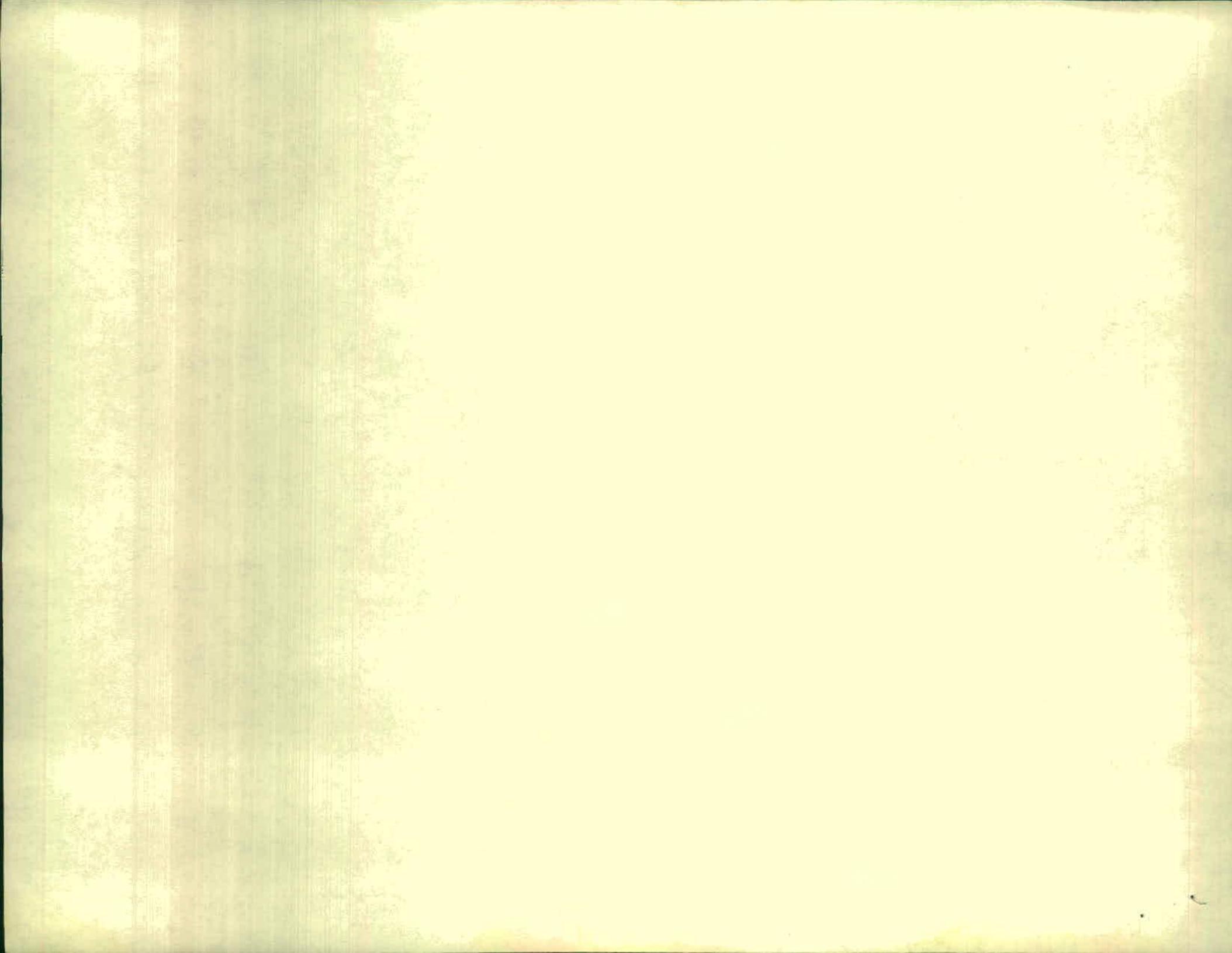


UNCONTROLLED COPY
SUSCEPTIBLE TO AMENDMENT
WITHOUT NOTICE
BY ORDER

D2282-5 STEM:

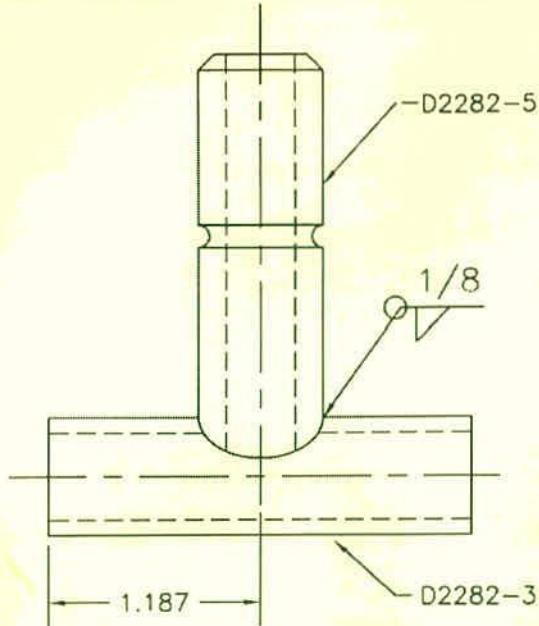
1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 26811 D

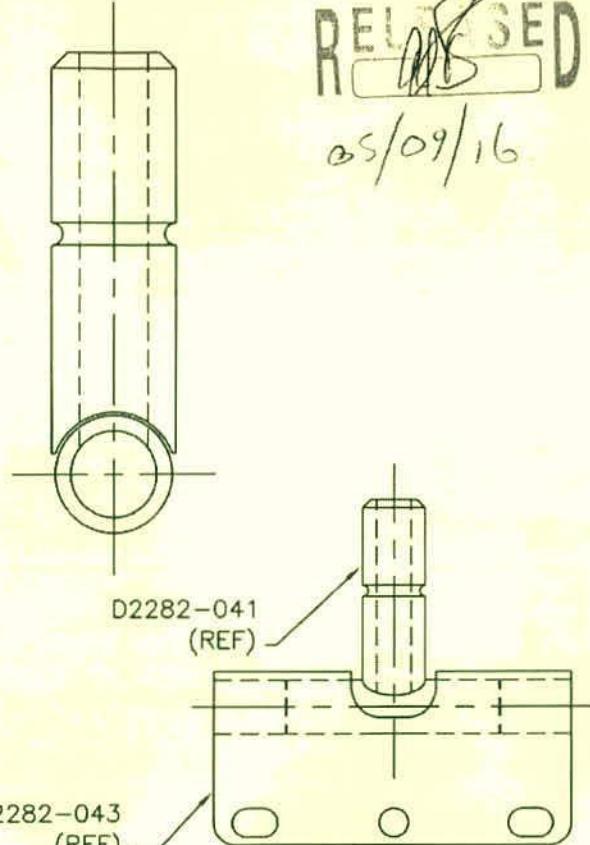


DART

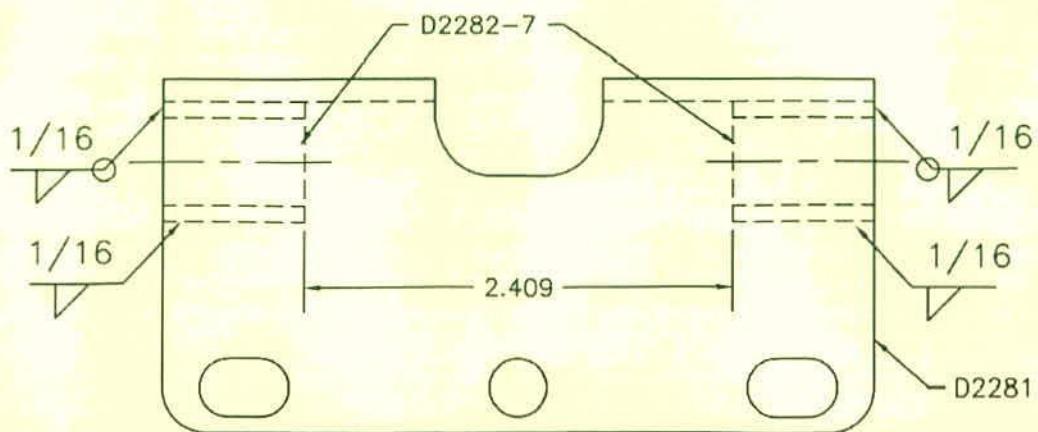
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AS</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26811B*

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